Need finished for Monday June 4

Work Order ID 85037

May-31-12 3:15:03 PM

85037

Item ID: D2196-3

Revision ID:

Item Name: Spacer

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 31/05/2012 **Start Qty:** 1.00

Required Date: 14/06/2012 **Req'd Qty:** 1.00

~~*1*~~ 4A

~~*1*~~

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 12/05/31 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2196	**Revision Nbr** Rev C								
100 *100* Waterjet FLOW CNC Waterjet ~~20x4 .500~~"?	FLOW WATER JET **Memo** 1-Cut as per Dwg D2196 Dwg Rev: C Prog Rev: C 2-Deburr if necessary	0.00 0.00				4	0		JM 12-6-1
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				4	0		JM 12-6-1
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 S12/06/01				(x4)			

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 85037
May-31-12 3:15:03 PM

85037

Item ID: D2196-3
Revision ID:
Item Name: Spacer

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 31/05/2012 **Start Qty:** 1.00 *1*
Required Date: 14/06/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____
QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab **Memo** 1-open hole to finish size as per dwg2- deburr	0.00 0.00				(1)			SB 12/06/04
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 S 12/06/04				(SE)			
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				1		26	12-6-4

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Work Order ID 85037 *85037*

May-31-12 3:15:03 PM

Item ID: D2196-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Spacer **Stop** *NS2*

Start Date: 31/05/2012 **Start Qty:** 1.00 *1*

Required Date: 14/06/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				4X			12/06/04
170 *170* Packaging Packaging	Identify as per dwg & Stock Location:______ **Memo**	0.00 0.00				4X			12/06/04
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00							12/6/78

MF 12-06-05

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ___________________ **Disposition:** ____________________ **QA: N/C Closed:** _________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-31-12 3:15:07 PM

Work Order ID: 85037

Parent Item: D2196-3

Parent Item Name: Spacer

85037
D2196-3

Start Date: 31/05/2012 **Required Date:** 14/06/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
**			No						**				

M6061 T6S.125 B# 121473 ~~0.803 SF~~ 0.3855 SF JM 12-6-1

12.06.01 12/6/1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	85037
Description: Spacer	Part Number:	D2196-3
Inspection Dwg: D2196 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.128"	✓		V	MM01
4.000	+/-0.010	3.993"	✓		V	MM01
3.74	+/-0.030	3.739"	✓		V	MM01

Measured by:	JM	Audited by:	[signature]	Prototype Approval:	N/A
Date:	12-6-1	Date:	12/06/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD [signature]	[signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

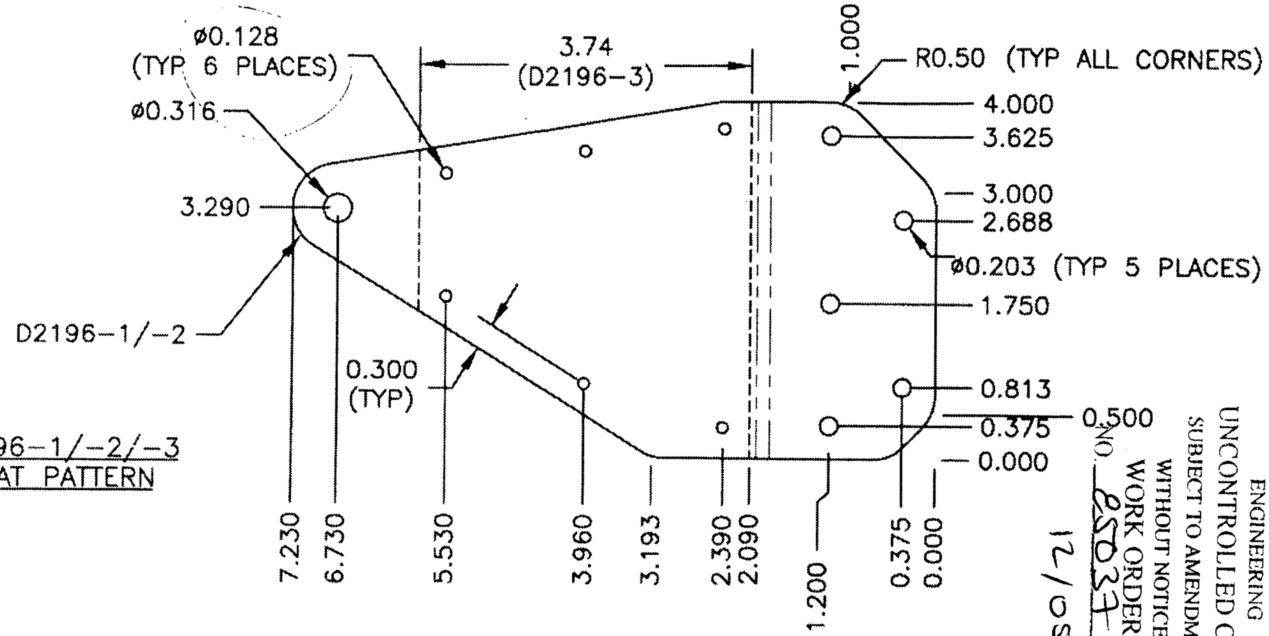
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2196 — REV. C — SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET — SCALE 1:2

B	93.09.23	REDESIGN
C	03.05.28	REDRAW; D2196-3 NOW 0.5" THICK



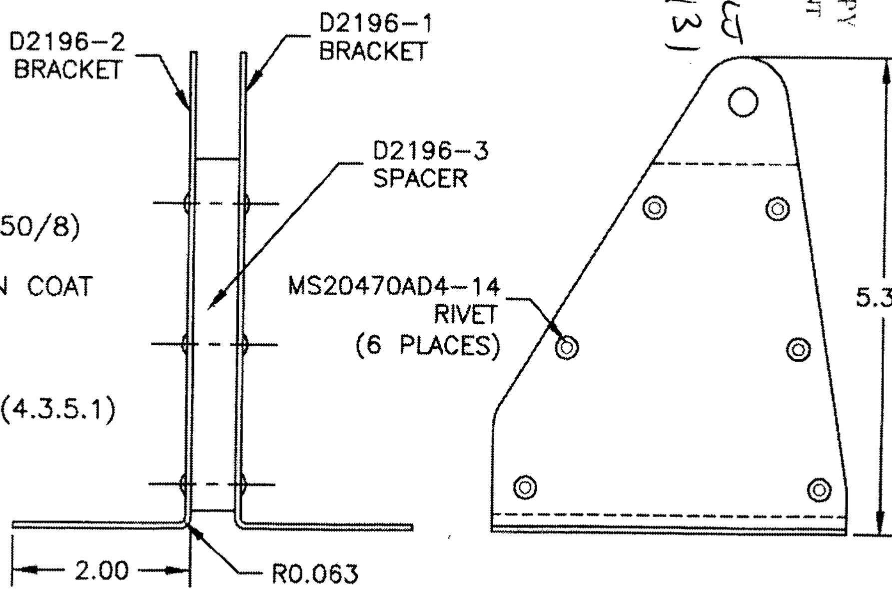
D2196-1/-2/-3
FLAT PATTERN

D2196-1/-2
1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2196-3
2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):
4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:
5) ALL DIMENSIONS ARE IN INCHES
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2196 BRACKET
(ASSEMBLY)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B						
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries